

Work Order ID 64550

Wednesday, December 08, 2010 10:12:13 A



Page 1

Item ID: D3315-5	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Wearplate					
Start Date: 12/8/2010	Start Qty: 3.00		Cust Item ID:		
Required Date: 12/22/2010	Req'd Qty: 3.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>M</u>	Date: <u>10-12-8</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3315	Rev B								

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
1010 .000	I-Cut as per Dwg D3315		<input checked="" type="checkbox"/> Dwg Rev: <u>B</u>	<input type="checkbox"/> Prog Rev: <u>B</u>	<input type="checkbox"/> 2-				
	Deburr if necessary								

B10-12-22

(3)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

B10-12-22

120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

81012/23

(X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Page 2

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00							
Brake NC	Memo	0.00							
	1- Form using DT8751 Die as per Dwg D3315 Rev: <u>B</u> 11/6/03								
	DT8179 Die as per Dwg D3315 Rev: <u>B</u>								
140  QC	QC6- Inspect dimensions to drawing	0.00							
Quality Control	Memo	0.00							
150  Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00							
	Weld hard surface using D3315-5T3 as per QSI 004 and Dwg D3315 Rev: <u>B</u>								
	<u>B</u> Qty Part Number Description Batch A/R								
	N/A 7560 Hardcoat Rod <u>M 115553</u>								

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____





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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Page 3

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Required Date:	12/22/2010	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		Sublet 13		3			
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sublet 13		3			
180  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 2:20 FINISH TIME: 2:50	0.00 0.00				3			11-01-13.

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 64550

Wednesday, December 08, 2010 10:12:13 A

Page 4

Item ID: D3315-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 12/8/2010 Start Qty: 3.00

Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

3 0 All 11/01/14

200

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: ☐ TCCA-PDA, Dart Aerospace Ltd. ☐ P/N: D3315-5, B/N: BXXXXX ☐ For Product Eligibility see PDA04-17 ☐ and Stock ☐ Location: 496A

11/14/14 (32)

Pho →

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00


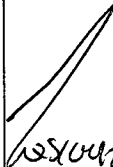


Quality Control

11/01/17

Close pull on 40 64556

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3315-5 PAR #: _____ Fault Category: Small Fabs NCR: Yes No DQA: [Signature] Date: 11/01/14
 Resolution: rework Disposition: rework QA: N/C Closed: [Signature] Date: 11/3/17

NCR: 64550		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/01/14	# 140	D3315-6 Found at step #200 when pulling for P Kits that all qty x3 were bent + inspectors wrong. Parts should be -6 not -5's.	 RESOURZ	Re-identify re-identify as AS -6 wear plates D3315-6 B64550 Qty x3	CU 11/01/14		 RESOURZ	S 11/01/14
		R.L. Day was read wrong and inspectors incorrectly. LOA Inspector realized error	 RESOURZ	- retrain inspector + employee that bent wear plate record on J.T log.	S 11/01/14		 RESOURZ	S 11/01/14
		D3315-5		will close & repull on w/o 64556 (D3315-6)				

NOTE: Date & initial all entries

Picklist Print

Wednesday, December 08, 2010 10:12:17 AM

Page 1

Work Order ID: 64550



Parent Item: D3315-5



Parent Item Name: Wearplate


Start Date: 12/8/2010

Required Date: 12/22/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP: A ☐ 05.05.12 ☐ New issue ☐ KJ/JLM ☐
IPP Rev:B As per Rev B 06-03-24 JLM
IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA  1010/1025 sheet 16GA		Purchased	No			100	sf	84.5250	1.8345	5.793158			



B10-12-22

Location

MAT19

111410

Loc Qty

84.525

84.525

Loc Code

111410

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	64530
Description: Wearplate		Part Number:	D3315-5
Inspection Dwg: D3315 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.31	+/-0.030	34.31	X		T R01	
30.215	+/-0.010	30.215	X		T	
24.215	+/-0.010	24.215	X		T	
21.611	+/-0.010	21.611	X		T	
17.965	+/-0.010	17.965	X		T	
16.026	+/-0.010	16.026	X		T	
14.735	+/-0.010	14.735	X		T	
12.815	+/-0.010	12.815	X		T	
6.465	+/-0.010	6.465	X		T	
5.400	+/-0.010	5.465	X		V R02	
4.527	+/-0.010	4.525	X		V	
3.550	+/-0.010	3.555	X		V	
5.214	+/-0.010	5.207	X		V	
Ø0.300	+0.006/-0.001	.304	X		V	
Ø0.266 x 0.575	+/-0.010	266 x .579	X		V	
Ø0.266 x 0.450	+/-0.010	266 x .450	X		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-12-02	Date: 10/10/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.22	New Issue	KJ/EC/DD	DS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

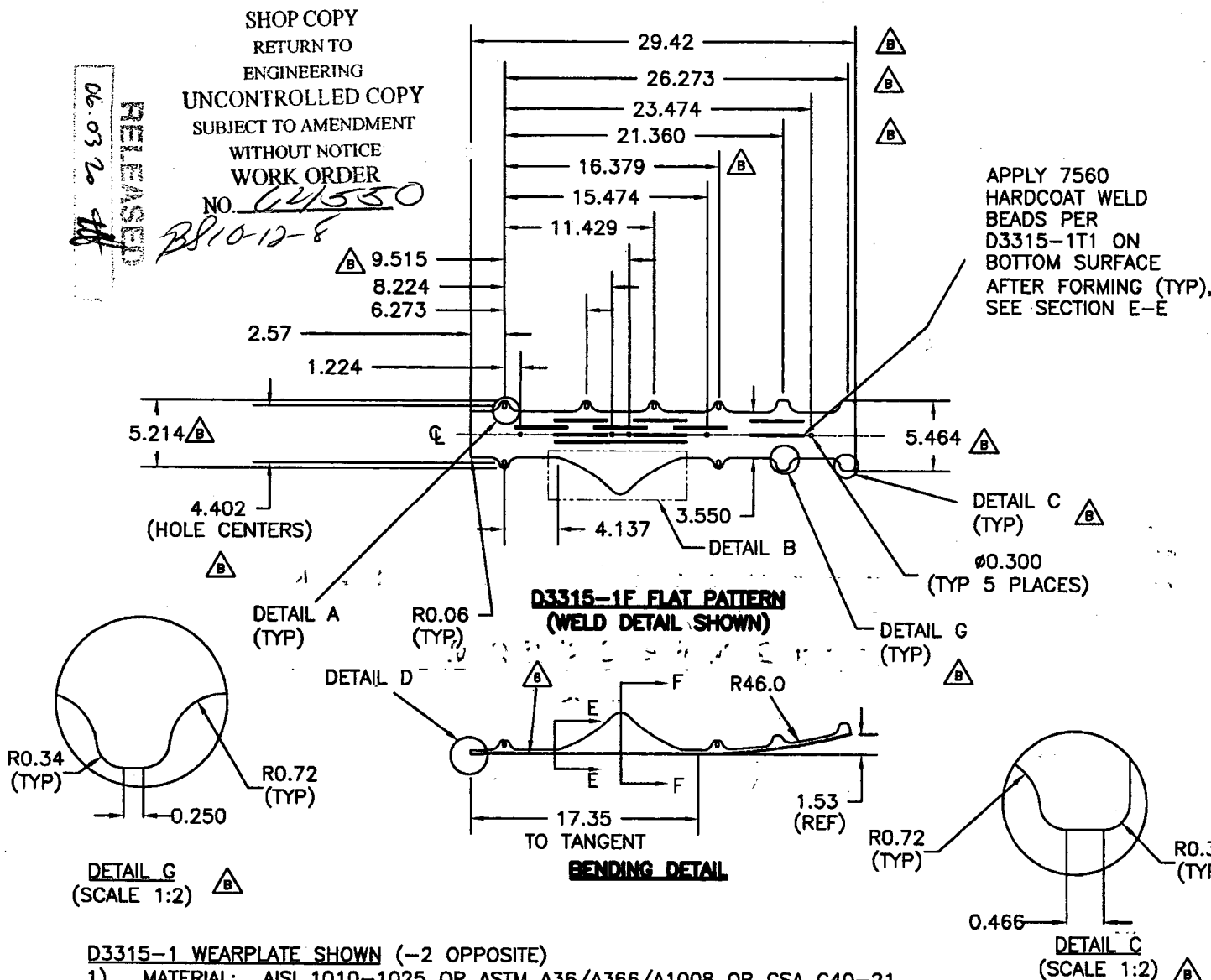
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
04	04	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3315
DATE	TITLE	SCALE
06.01.31	WEARPLATE	1:12
A	NEW ISSUE	REV. B
04.09.10		
B	UPDATE DIMENSIONS	SHEET 1 OF 4
06.01.31		



D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

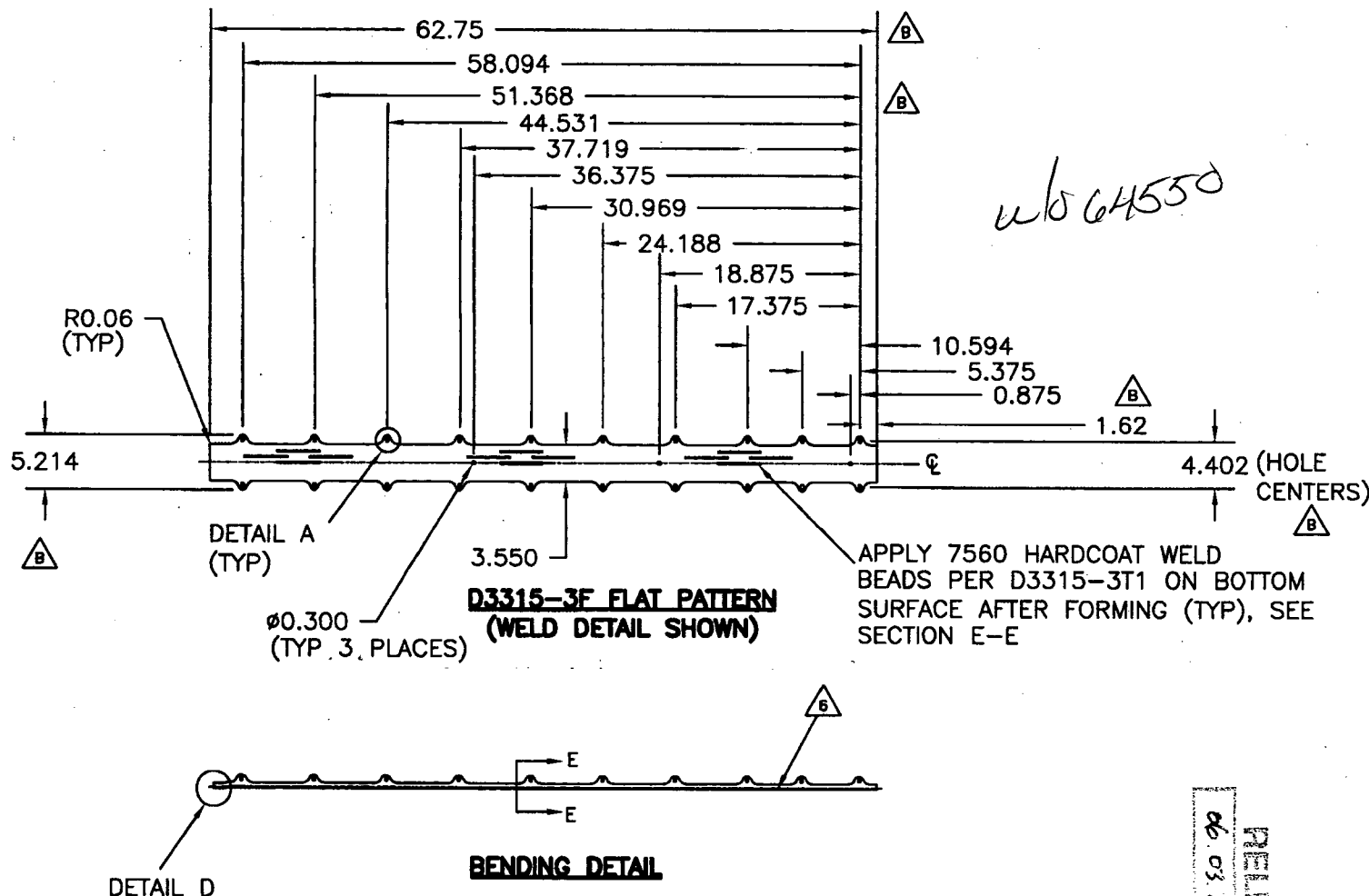
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	84	DRAWN BY	84	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAMKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
		TITLE	WEARPLATE	SHEET 2 OF 4
		SCALE	1:16	



D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

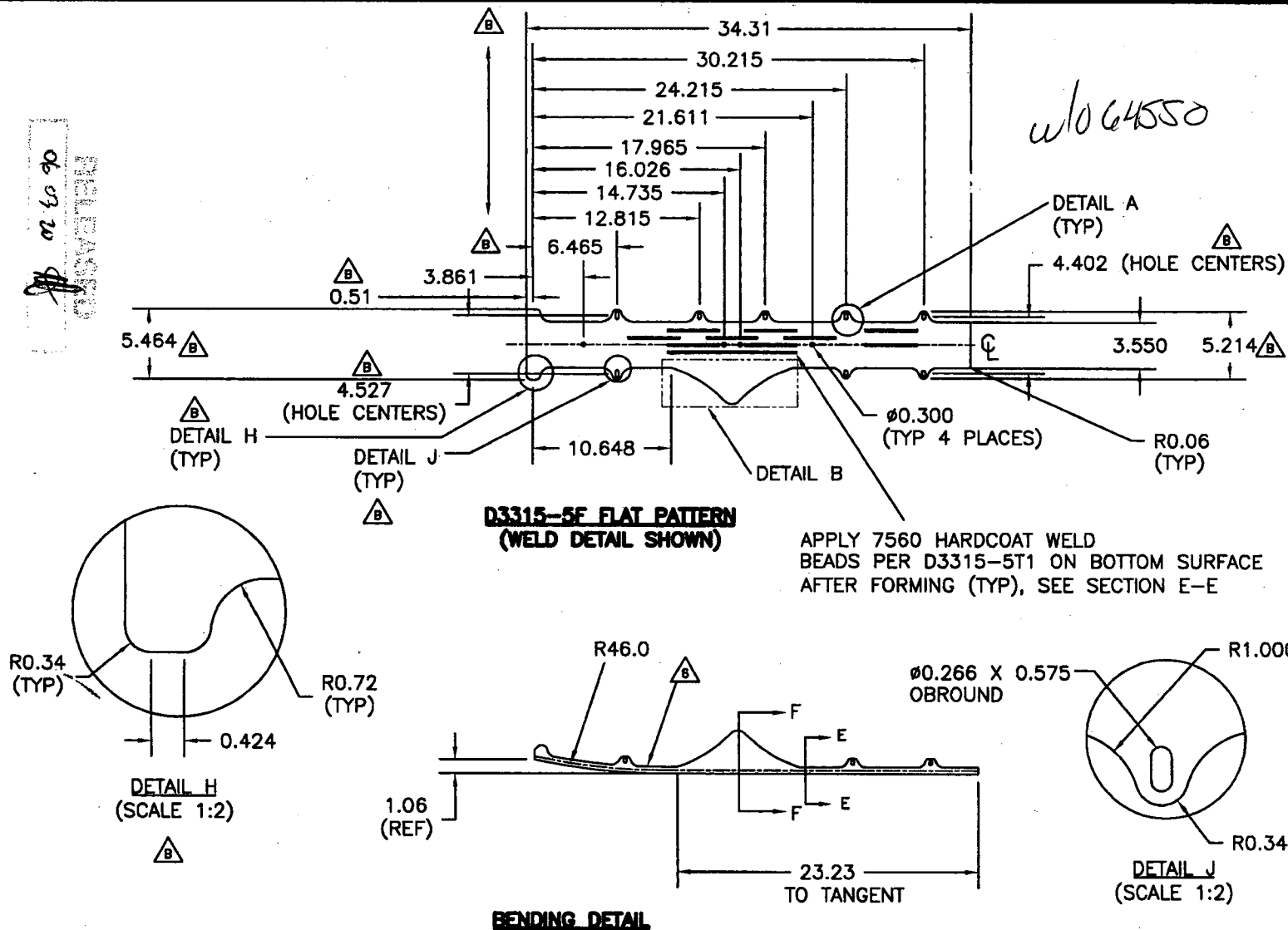
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	014	DRAWN BY	014	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3315
DATE	06.01.31	TITLE	WEARPLATE	SHEET 3 OF 4
				REV. B
				SCALE 1:12



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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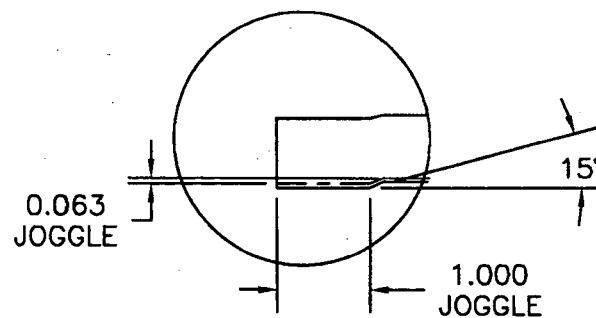
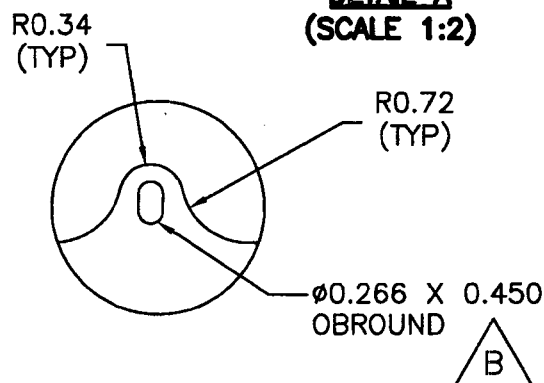
NOTE: Date & initial all entries



DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. B
DATE	06.01.31	TITLE	D3315	SHEET 4 OF 4	
		WEARPLATE		SCALE	
				NTS	

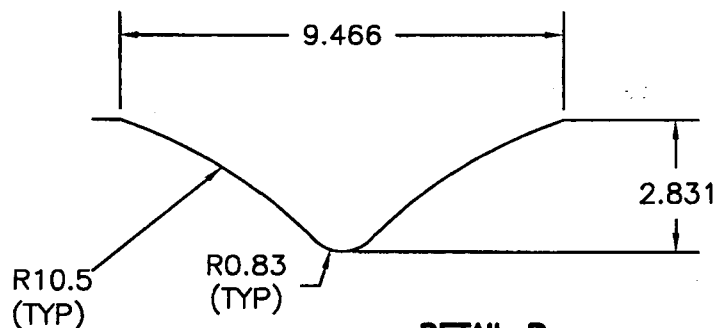
W64550

DETAIL A
(SCALE 1:2)

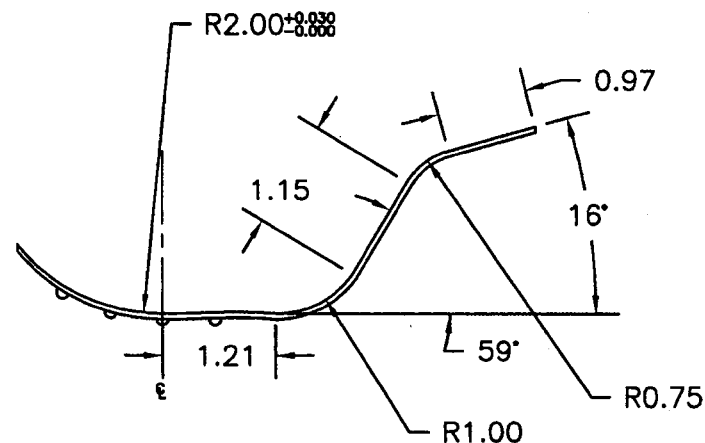
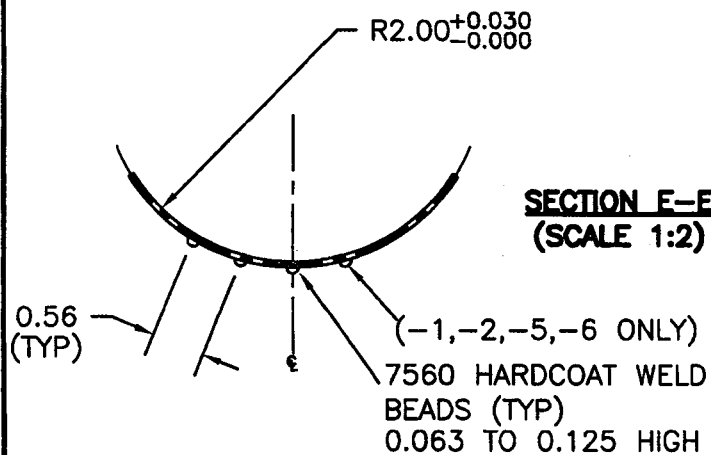


DETAIL D
(SCALE 1:2)

DETAIL B
(SCALE 1:4)



SECTION F-F
(SCALE 1:2)



SECTION F-F
(SCALE 1:2)

06.03.20
RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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